

Work Order ID 78901

78901

Page 1

January-17-12 11:52:04 AM

Item ID: D3793-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearshoe
 Start Date: 17/01/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/17 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3793 Dwg Rev: A Prog Rev: A 2-
30.00 Deburr if necessary

B12-1-30

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control

B12-1-30

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control

Sizel/30

414

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00							
130						(13)			
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793								

140	QC5- Inspect part completeness to step on W/O	0.00							
140						(43)			
QC	Memo	0.00							
Quality Control									

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:50 OVEN TEMPERATURE: 320°F FINISH TIME: 2:20								

M 118489

13X7 M-1 12/22/02

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Work Order ID 78901***78901***

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
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160

QC

Memo

0.00

Quality Control

13 1222

170

Identify as per dwg & Stock Location FD-1

0.00

170

Packaging

Memo

0.00

Packaging

13 1222

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

M.L.J 12/02/03 12/02/03
(17)

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NOTE: Date & initial all entries

Picklist Print

January-17-12 11:52:07 AM

Page 1

Work Order ID: 78901

78901

Parent Item: D3793-1

D3793-1

Parent Item Name: Wearshoe

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

225.5165

0.5902

7.455158

8.

M304S20GA

**

B12-1-30

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

225.5165

116623

0.2

117933

27.3442

118400

25.6723

118964

36.5

119346

135.8

116346

(13)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 78901
Description: Wearshoe		Part Number: D3793-1
Inspection Dwg: D3793	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.190	2		V B02	
0.300 x 0.300	+/-0.010	305 x 303	2		V	
1.885	+/-0.010	1.891	2		V	
2.000	+/-0.010	2.000	2		V	
5.00	+/-0.030	5.00	2		T B01	
8.00	+/-0.030	8.06	2		T	
14.00	+/-0.030	14.00	2		T	
20.00	+/-0.030	20.00	2		T	
14.066	+/-0.010	14.066	2		T	
18.983	+/-0.010	18.983	2		T	
23.900	+/-0.010	23.900	2		T	
27.400	+/-0.010	27.400	2		T	
29.400	+/-0.010	29.400	2		T	
32.900	+/-0.010	32.900	2		T	
0.040	+/-0.010	0.038	2		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 12-1-36	Date: 12/01/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

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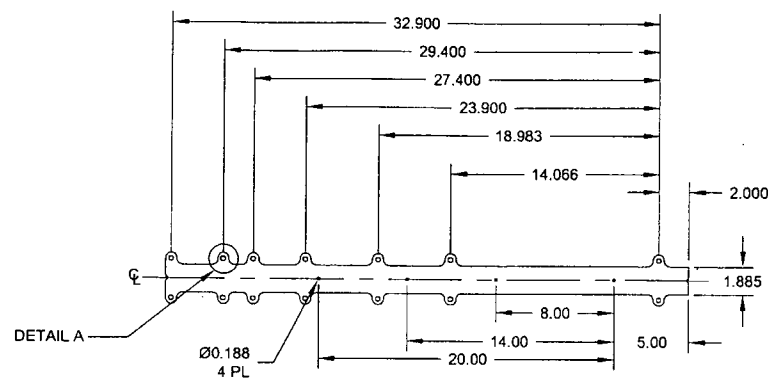
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

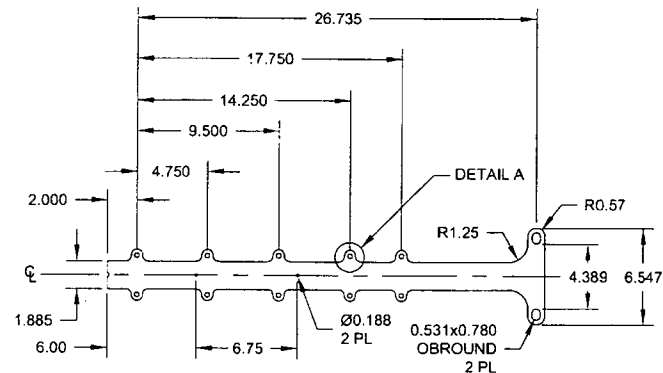
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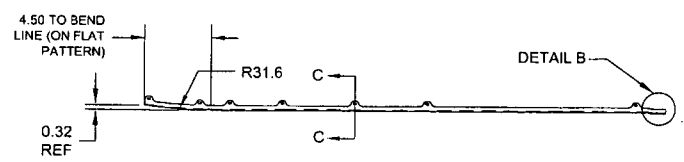
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

SHOP COPY
RETURN TO
FACILITY
UNCONTROLLED COPY
SUBJECT TO ALL NOTICES
WITHOUT NOTICE
WORK ORDER
NO. 78901 M.L.J
12/01/17

RELEASED
08.05.14

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
 - 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	08.05.14
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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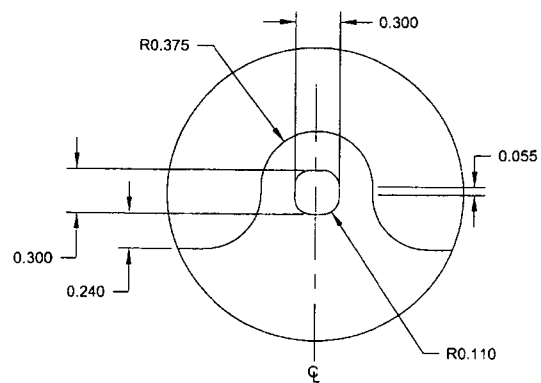
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78901

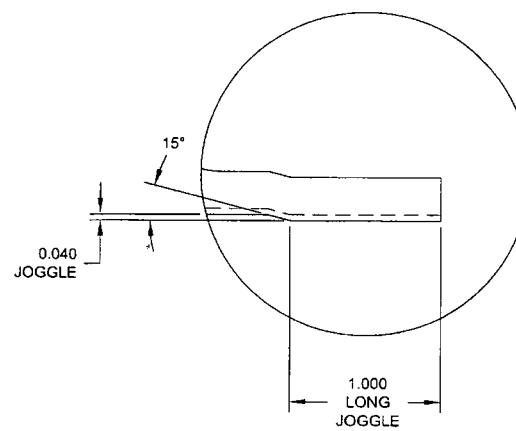
8 7 6 5 4 3 2 1

D
C
B
A

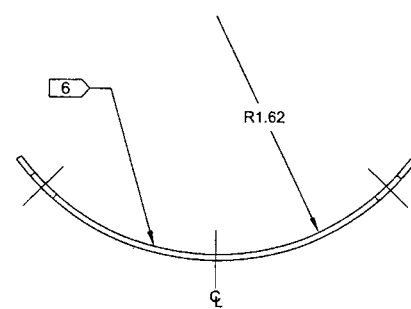
D
C
B
A



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08-05-25/102

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS REVENUE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

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